

January-13-12 10:44:14 AM

Page 1

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 13/01/2012    **Start Qty:** 2.00

\*2\*

**Cust Item ID:**

**Required Date: 27/01/2012      Req'd Qty: 2.00**

\*2\*

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.J

Date: 12/01/13 Tooling:

Date:

Run Start \*NR1\*

**QC:**

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(2)			
D3135	Rev D								
100		0.00							
*100*	FLOW WATER JET								
Waterjet	Memo	0.00							B 12-8-
FLOW CNC Waterjet	1-Cut as per Dwg D3135    Dwg Rev: <u>D</u> Prog Rev: _____ 2-								
364 . 063	Deburr if necessary								
010		0.00							
*110*	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							B 12-8-1
Quality Control									
120		0.00							
*120*	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00	SMB						
Quality Control			12-8-07						
				DAS					
				16					
				12/06/07					
						2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78748

January-13-12 10:44:14 AM

**\*78748\***

Page 2

Item ID: D3135-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Handle Weldment  
 Start Date: 13/01/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 27/01/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Small Fab					2	0		FF 12-08-08
Small Fab	Memo	0.00							
Small Fab	1-Bend D3135-1 as per template D3135-1T2 and Dwg D31352-Debur ends								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O					2			
QC	Memo	0.00	Smb						
Quality Control		12-8-08							
150		0.00							
<b>*150*</b>	Large Fab					2			12-8-9
Large Fab	Memo	0.00							
Large Fab	1-Weld handle onto plate as per Dwg D3135 and QSI 004 304 S.S. welding rod Batch: <u>M114509</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78748

January-13-12 10:44:14 AM

**\*78748\***

Page 3

Item ID: D3135-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Handle Weldment  
 Start Date: 13/01/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 27/01/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				2	12.8.9		DAS 24 8-89
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				2	12.8.9		DAS 24 8-89
180 <b>*180*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 3h50 320°F FINISH TIME: 4h20	0.00  0.00				2	x	(DP)	12/08/09.

OVEN TEMPERATURE: m. 21 279✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78748

January-13-12 10:44:14 AM

**\*78748\***

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Item ID: D3135-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Handle Weldment  
 Start Date: 13/01/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 27/01/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2X		SP	12-8-10
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location <b>236B</b>  Memo	0.00  0.00				2x		12/8/10	
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						12/8/13	MS 12/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January-13-12 10:44:18 AM

Page 1

Work Order ID: 78748

\*78748\*

Parent Item: D3135-041

\*D3135-041\*

Parent Item Name: Handle Weldment

Start Date: 13/01/2012

Required Date: 27/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A03.03.06New IssueKJ/RF  
IPP Rev:B 08-01-15 now on water jet DD  
IPP Rev:C 08-05-22 revD as per dwg ECN1192 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.375W.065

Purchased

No

100

f

52.2500

0.4167

0.877263

\*M304TR0 375W 065\*

\*\*

304 RD Tube .375 x .065W

② FF 12-08-08

Location

Loc Qty

Loc Code

MAT016

52.25

111097

1.75

120183

50.5

M304S16GA

Purchased

No

130

sf

97.3300

0.3

0.631579

\*M304S16GA\*

\*\*

304/316 Sheet .063

B12-8-7

Location

Loc Qty

Loc Code

MAT020

97.33

119346

29.5

119653

67.83

122245

122245

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

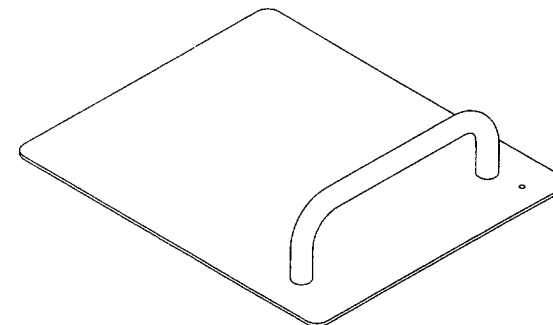
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

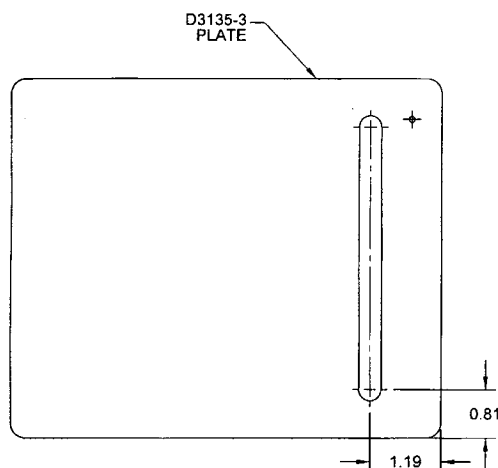
**NOTE:** Date & initial all entries

QTY. -041	PART NUMBER	DESCRIPTION
X	D3135-041	HANDLE WELDMENT
1	D3135-1	HANDLE
1	D3135-3	PLATE

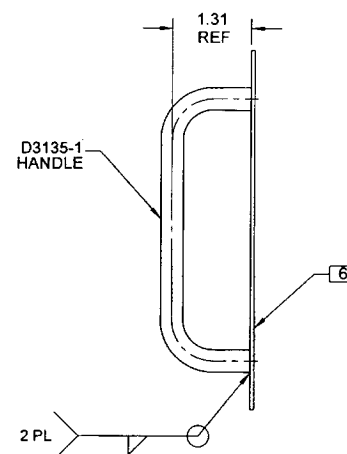
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
NO - 78748 M.C.J  
12/01/13



**D3135-041 HANDLE WELDMENT**



**D3135-041 HANDLE WELDMENT**



**RELEASED**  
08-05-22

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT COLOUR GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3135-041" AND BATCH "BXXXXX" USING FINE POINT PERMANENT INK MARKER OR FIX LABEL AFTER FINISHING
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004

D	REDRAWN TO SOLIDWORKS FORMAT. ZN D4-2 TOOLING HOLE ADDED. REASON: PRODUCTION REQUEST FOR TOOLING HOLE.	AJS	08.05.07
C	REMOVED Ø0.221 HOLES	DS	04.10.06
B	6.400 WAS 6.330; ADD "ANNEALED"	DS	03.03.04
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3135	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HANDLE WELDMENT	NTS
DATE	08.05.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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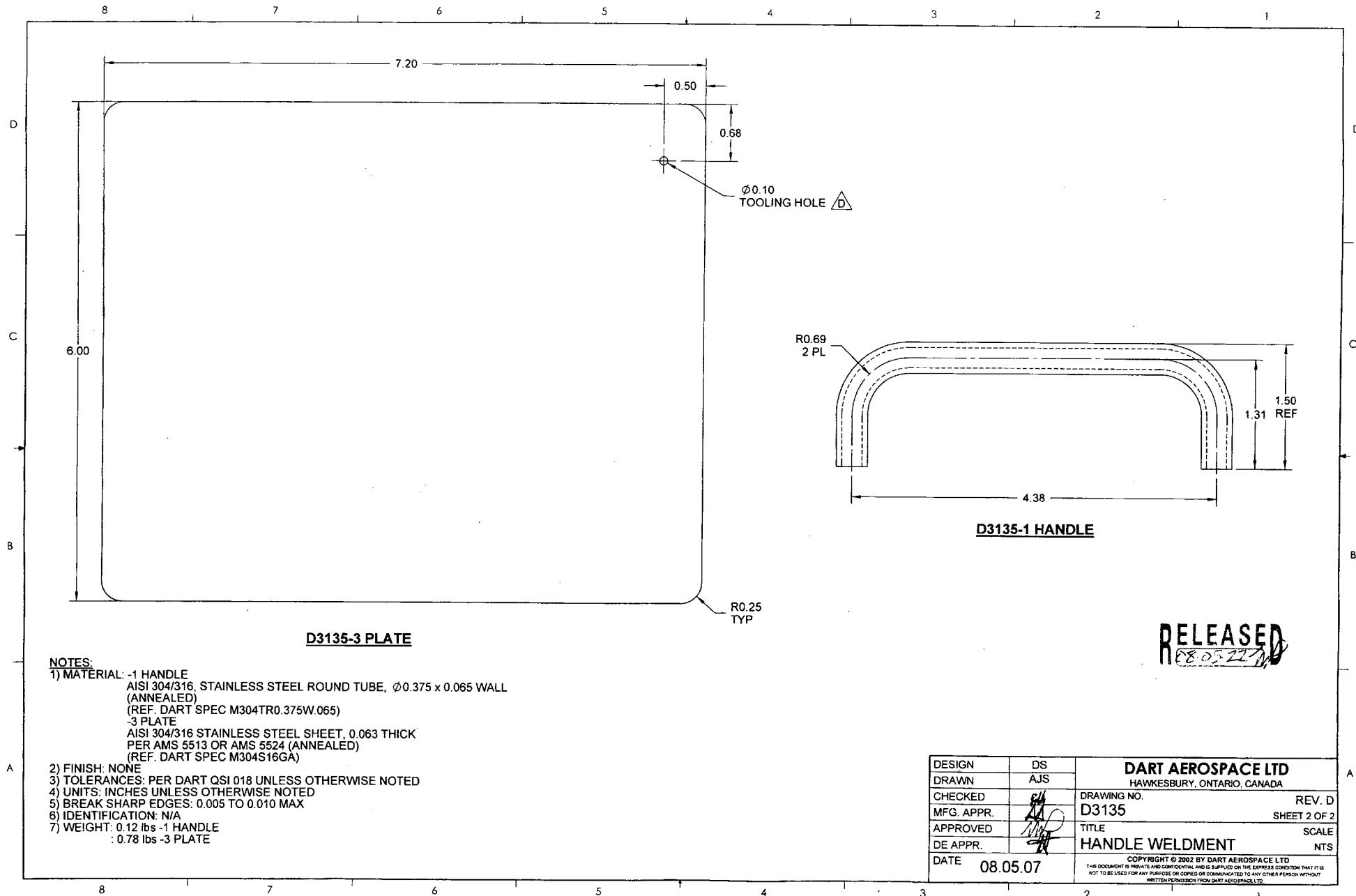
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78748



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

